

January-08-14 12:53:26 PM

Page 1

DEBURR

DQA:

Date: 14/07/30



QA Closed:

Date: 14/11/27

## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>111073</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D4875-7</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3449</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Part scrap.		Scrap + Destroy.	14-01-22	DAS 27 0-00	
Doc/Data				Operator took wrong	14/01/22	Replate		14/1/23	14/01/22
Equip/Tooling				original	Q5202	B 122 094			Q52012
Handling/Pre				RC. operator error /					
Material				no verification before					
Operator	X			Start					
Offset/Setup	14/01/22	#							
Process		1A0							
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<input type="checkbox"/> Set-up
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
			<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

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**\*NR2\***

## Packaging

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 111073****\*111073\***

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Item ID: D4875-7

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Fwd Attachment Clevis

Start Date: 1/08/14

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/08/14

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

MLJ 14-01-27

① 14.01.23

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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Offset/Setup									
Process									
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Transport									
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# Picklist Print

January-08-14 12:53:26 PM

Page 1

Work Order ID: 111073

Parent Item: D4875-7

Parent Item Name: Fwd Attachment Clevis

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE JFS 13/09/03 VERIFY BY:DD  
DWG REV.C DD VERF:JLM

IPP REV:B 13.08.21 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.500X1.500 304 bar 1.50 X1.50		Purchased	No			100	f	10.0000	0.284	1.1957896 1.200'		14-01-21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT049		10							
				122094		10			1.200'				

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Operator									
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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 111073
<b>Description:</b> D4875-7 FWD Attachment Clevis	<b>Part Number:</b> D4875-7
<b>Inspection Dwg:</b> D4875 <b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.41	+/- .030	.405	✓		SL08	Vern
.360	+/- .010	.351	✓			
R.13	+/- .030	.130	✓		Rad gauge	
1.99	+/- .030	1.996	✓			
.188	+/- .010	.181	✓			
1.170	+/- .010	1.170	✓			
.795	+/- .010	.795	✓			
R.06	+/- .030	.063	✓		Rad gauge	
Ø.125	+ .004/- .001	.126	✓		Gauge Pins	
Ø.266	+ .006/- .001	.267	✓		"	
Ø.257	+ .006/- .001	.259	✓		"	
.75	+/- .030	.753	✓		↓	
.38	+/- .030	.375	✓			
.38	+/- .030	.375	✓			
.875	+/- .010	.875	✓			
2.485	+/- .010	2.485	✓			
3.23	+/- .030	3.238	✓		↓	
R.38	+/- .030	.380	✓			Rad gauge
105°	+/- .5°	105°	✓		Protractor	

<b>Measured by:</b> <i>SP</i>	<b>Audited by:</b> <i>L.A.</i> <sup>DAG</sup> <sub>08-89</sub>	<b>Preliminary Approval:</b>
<b>Date:</b> 14-01-22	<b>Date:</b> 14/01/22	<b>Date:</b>

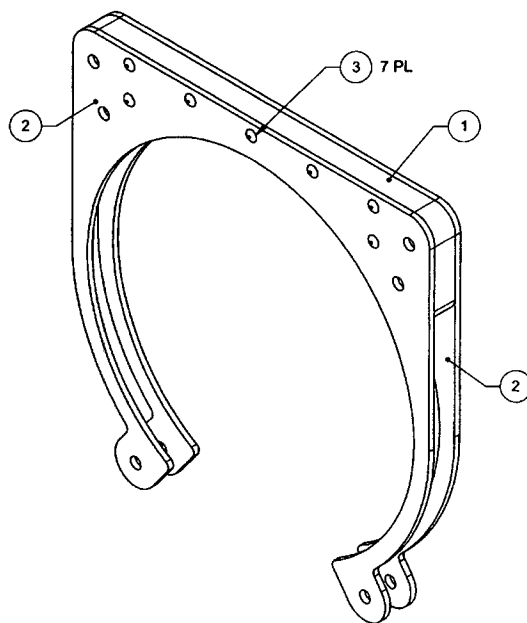
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*

65

111073  
MLJ  
14-01-10

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4875-041	CARGO TUBE BRACKET ASSY
1	1	D4875-1	CARGO TUBE BLOCK
2	2	D4875-3	CARGO TUBE BRACKET
3	7	MS20470AD4-15	RIVET

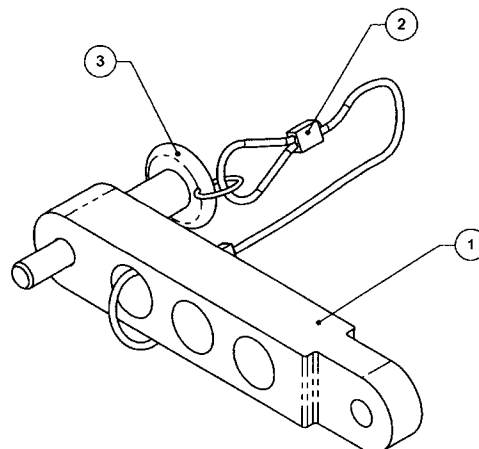


**D4875-041 CARGO TUBE BRACKET ASSY**

**NOTES:**

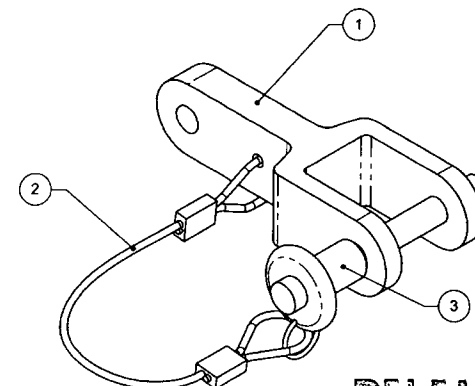
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.13 lbs  
-043: 0.20 lbs  
-045: 0.29 lbs

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4875-043	TUBE STRUT ASSEMBLY
1	1	D4875-5	CARGO TUBE AFT STRUT
2	1	D2690-5	LANYARD
3	1	MS17984-C410	QUICK RELEASE PIN



**D4875-043 TUBE STRUT ASSEMBLY**

ITEM	QTY -045	P/N	DESCRIPTION
	X	D4875-045	FWD ATTACHMENT CLEVIS ASSY
1	1	D4875-7	FWD ATTACHMENT CLEVIS
2	1	D2690-4	LANYARD
3	1	MS17984-C412	QUICK RELEASE PIN



**D4875-045 FWD ATTACHMENT CLEVIS ASSY**

**RELEASED**  
2013-09-23

C	ADDED -045, REDESIGN -041 & -3 FOR EASE OF ASSEMBLY AT NEXT ASSEMBLY. SPACING FOR LIGHTENING HOLES IN -5 RETOLERANCED. -041 ITEM 3 WAS -16.	AJS	13.08.14
B	COMPLETE REDESIGN FOR 8" TUBE. ADDED -043.	AJS	13.06.11
A	NEW ISSUE	AJS	13.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	A.P.		
MFG. APPR.	N		
APPROVED			
DE APPR.			
DATE	13.08.14		

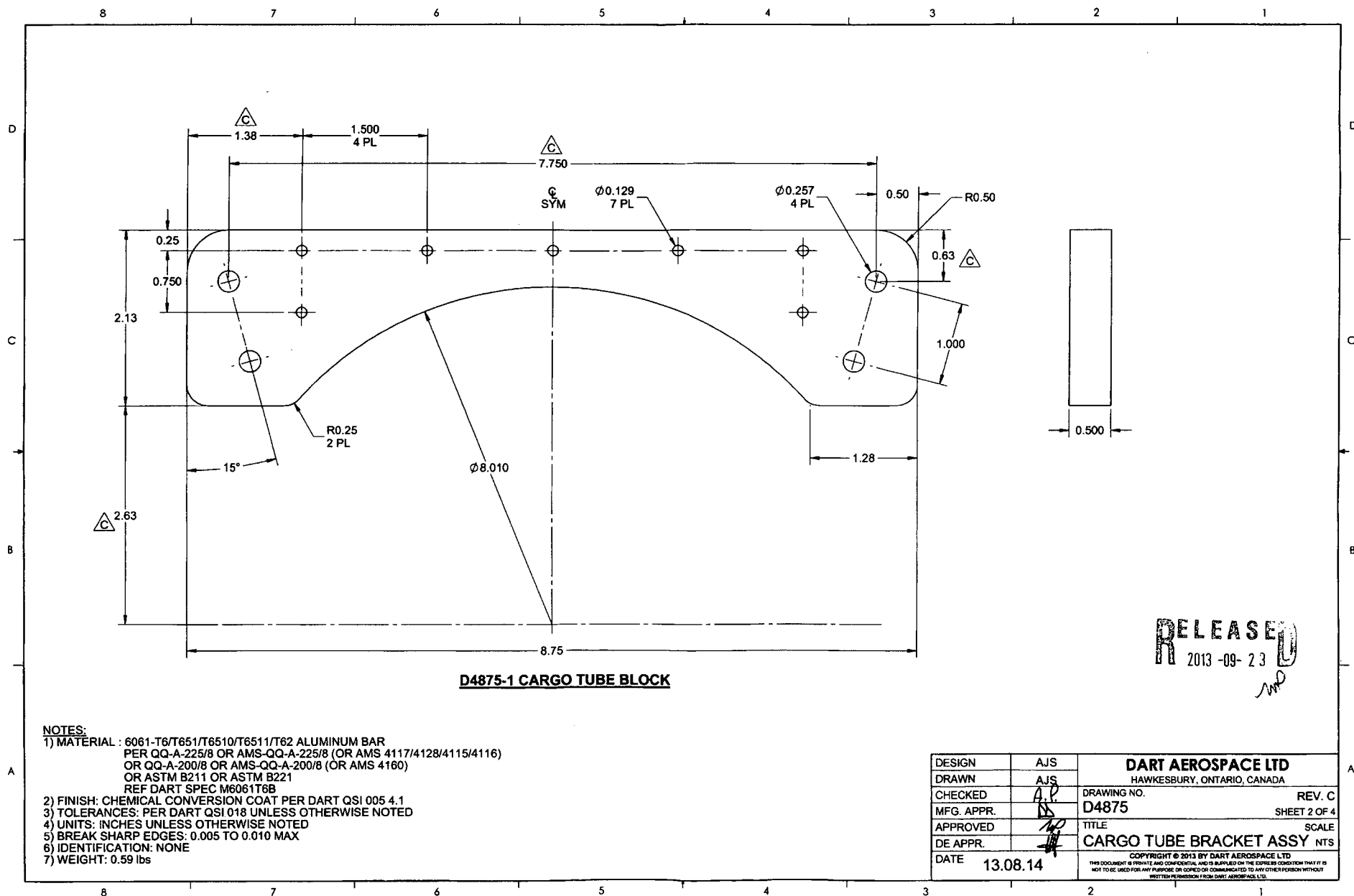
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4875** REV. C  
SHEET 1 OF 4

TITLE **CARGO TUBE BRACKET ASSY** SCALE NTS

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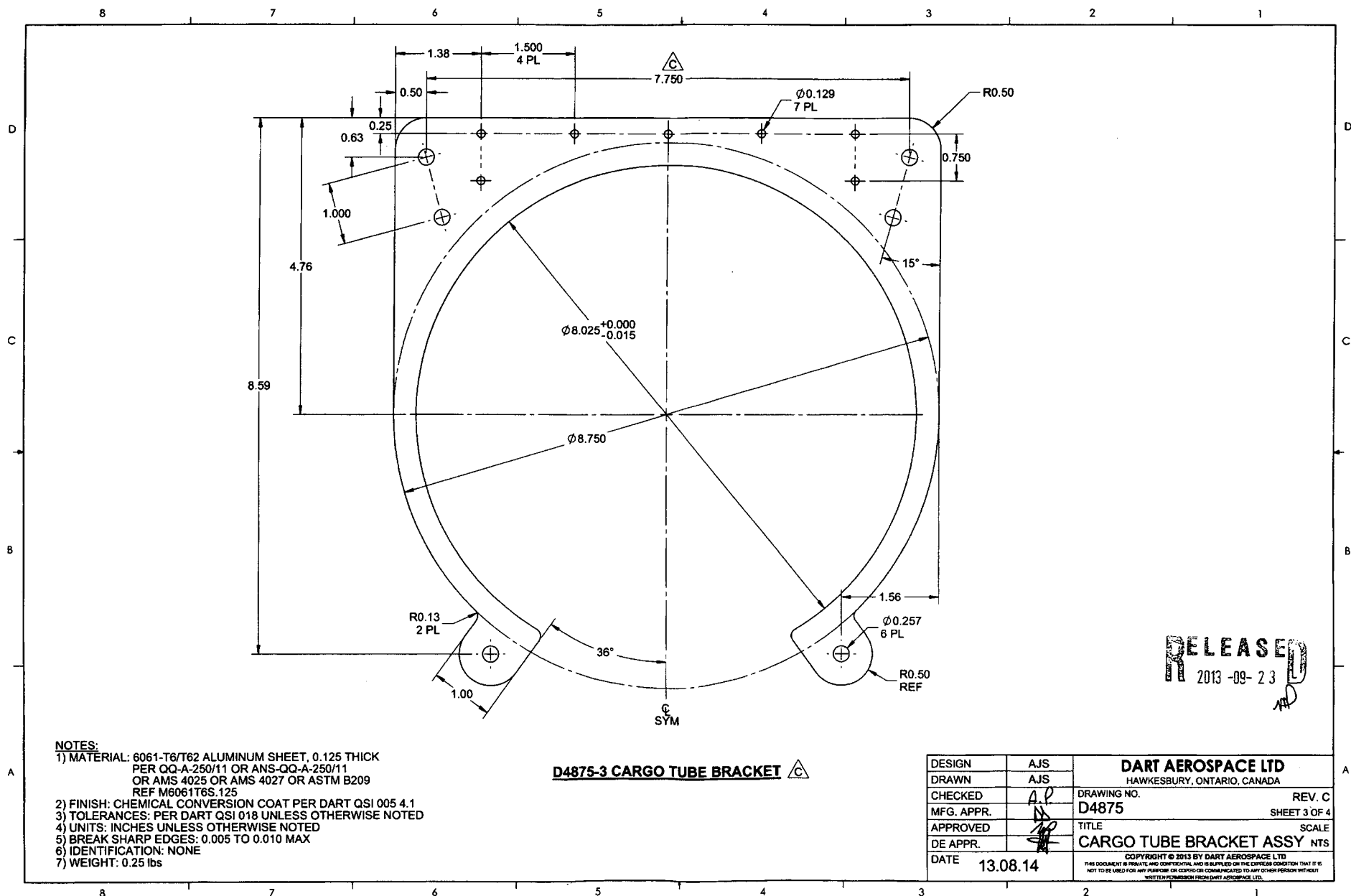
**NOTES:**

- 1) MATERIAL : 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.59 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	IS	<b>D4875</b>	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	<b>CARGO TUBE BRACKET ASSY</b>	NTS
DATE	13.08.14	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
2013-09-23





# NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK  
PER QQ-A-250/11 OR ANS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

## D4875-3 CARGO TUBE BRACKET C

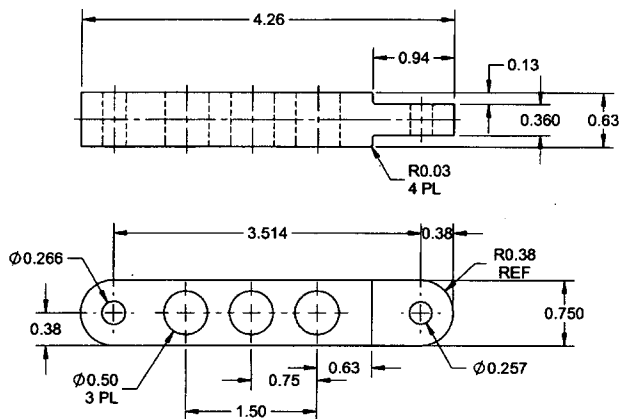
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	N	D4875	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	CARGO TUBE BRACKET ASSY NTS	
DATE	13.08.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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RELEASED  
2013-09-23





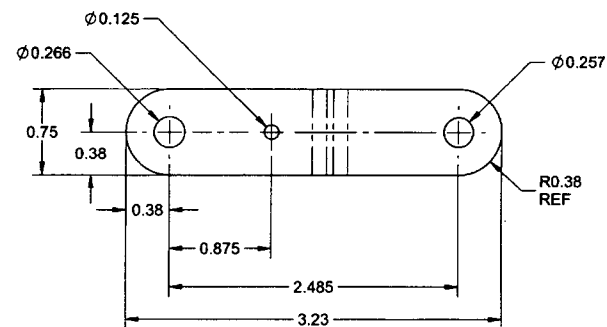
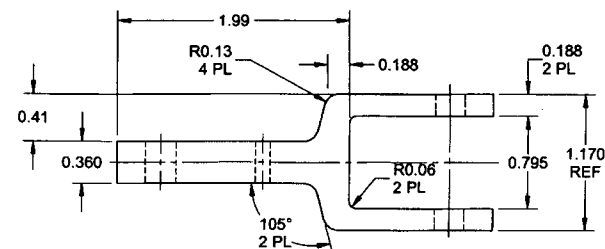
8 7 6 5 4 3 2 1



**D4875-5 CARGO TUBE AFT STRUT**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs



**D4875-7 FWD ATTACHMENT CLEVIS**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR  
PER ASTM A582 OR ASTM A276 OR ASTM A240  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

RELEASE  
2013-09-23

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	NS	D4875	SHEET 4 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	CARGO TUBE BRACKET ASSY	NTS
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8 7 6 5 4 3 2 1

